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D3414-041
Job Sheet 205356



Part No: D3414-041

Job Qty: 8 pcs

Part Name: Lug



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/8/20

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 1/27/20

Description:

Type: Stock

Note: DWG REV C IPP A 05.09.13 New issue KJ/JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
140	Large Fab - Welded Assy-1	8 pcs	1/27/20	1/27/20	0.00	1.60	Large Fab - 1		MV Feb 27/20
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
							Large Fab - 12		
150	QC 9	8 pcs	1/27/20	1/27/20	0.00	0.00	QC 9 - 10		12
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		
							QC 9 - 9		
160	QC 5	8 pcs	1/27/20	1/27/20	0.00	8.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		



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Container No: S258835



Part No: D3414-041

Job No: 205356

Serial No/Batch: S258835

Revision:
Director:

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					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	9
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
170	Powdercoat - 2 White Gl(S)- B4B	8 pcs	1/27/20	0.00 0.17	Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	BER 20-02-28.
					Powdercoat - 4 - B4B	
180	QC 3	8 pcs	1/27/20	0.00 8.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	MAR 02 2020
190	Packaging 3-1 - Stock - B4B	8 pcs	1/27/20	0.00 8.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	DAS
					Packaging 3 - 7 - B4B	28
					Packaging 3 - 8 - B4B	9-89
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	

DAS
82
9-89

				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
200 QC 21 - SA	8	1/27/20	0.00 8.00	QC 21 - SA - 21	DA
	pcs			QC 21 - SA - 70	21
				QC 21 - SA - 53	9-82

MAR 02 2020

Part Op 140 - (Weld per dwg A/R S.S. rod Batch M138974) 1- Weld using location Jig DT9625 as per Dwg D3414 A/R S.S.
 Descriptions: welding rod Batch: _____

150 - (QC9- Inspect visual per QSI004- Fusion Welds)

160 - (QC5- Inspect part completeness to step on W/O)

170 - (White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel) START TIME: _____ OVEN TEMPERATURE: _____

FINISH TIME: _____

180 - (QC3- Inspect Part Finish)

190 - (Identify as per dwg & Stock Location: _____)

200 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3414-3	Lug	8 pcs (1 ea)	140-Large Fab - Welded Assy-1	5230278
D3414-1	Lug Bracket	8 pcs (1 ea)	140-Large Fab - Welded Assy-1	5238662

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
140-Large Fab - Welded Assy-1	D3414-1	8	54	0
	D3414-3	8	44	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Lug Bracket	0.313inches	+ 0.006 - 0.001	0.319 0.312	
2	Lug Bracket	1.190inches	± 0.030	1.220 1.160	
3	Lug Bracket	1.000inches	± 0.030	1.030 0.970	
4	Lug Bracket	3.380inches	± 0.030	3.410 3.350	
5	Lug Bracket	5.350inches	± 0.010	5.360 5.340	
6	Lug Bracket	6.230inches	± 0.030	6.260 6.200	
7	Lug Bracket	2.500inches	± 0.010	2.510 2.490	
8	Lug Bracket	0.370inches	± 0.030	0.400 0.340	
9	Lug Bracket	0.100inches	± 0.010	0.110 0.090	

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Entered: _____

Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION ☐ Rework ☐ Scrap ☐ Use-as-is ☐ Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality		DEPARTMENT/PROCESS		MRB (QSI042)	
Date : _____		Sequence #: _____		QTY Affected : _____			
Description Work Order Deviation		Disposition					
Root Cause ☐ Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread							
Completed By		Lead hand / Supervisor					
QC / QA Coordinator		QC / QA Coordinator					